

Date: Wednesday, 23/07/2008 10:10:24 AM
 User: Jean-Luc Menard

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BRACKET ASSEMBLY |
| Job Number : 40250 | |
| Estimate Number : 10278 | |
| P.O. Number : | Part Number : D3121141 |
| This Issue : 23/07/2008 S.O. No. : | Drawing Number : D3121 REV E |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 04/07/2008 Type : MACHINED PARTS | Drawing Revision : E |
| Previous Run : 39921 | Material : |
| Written By : <u>J. Menard 07-23</u> | Due Date : 30/07/2008 Qty: 20 Um: Each |
| Checked & Approved By : | |
| Comment : Est Rev: Pick: A 04.02.18 New issue KJ/DS | |
| Est Rev: B ECN 1060 07-11-12 DD verified by: EC | |

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B1250X02000 17-4 SS Bar 1.250 x 2.00



Comment: Qty.: 0.5775 f(s)/Unit Total : 11.5500 f(s)
 Material: 17-4 SS Bar per AMS 5604/5643
 (M17-4-B1.250x02.000)
 Identify for D3121-111
 Batch: M108595

(20)

L.F 08/07/23

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: (1.000" x 2.000") 6.600" long

(20)

L.F 08/07/23

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111

2-Deburr

3-Scribe batch number

(20)

DIP 08/07/24 / L.F 08/07/25

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/07/24

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 40250

Part Number: D3121141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JA 08/07/28

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-21

Bolt

340284

EP 08/08/06

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-241 Bearing Ass

B40157

EP 08/08/08

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3121-141 as per Dwg D3121.

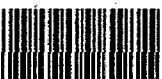
EP 08/08/06

(20)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/06

(420)

counted

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 233

AS 08/08/07

(420)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08

(20)

Job Completion



MF 08-08-07

| | | | |
|-------------------------------------|--|---------------------|-----------|
| DART AEROSPACE LTD | | Work Order: | 40250 |
| Description: Bracket | | Part Number: | D3121-111 |
| Inspection Dwg: D3121 Rev: E | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.392 | +0.002/-0.000 | 0.393 | ✓ | | | |
| 0.75 | +/-0.030 | 0.752 | ✓ | | | |
| 0.375 | +/-0.010 | 0.375 | ✓ | | | |
| 2.14 | +/-0.030 | 2.140 | ✓ | | | |
| 1.96 | +/-0.030 | 1.963 | ✓ | | | |
| 0.280 | +/-0.010 | 0.280 | ✓ | | | |
| 3.330 | +/-0.010 | 3.330 | ✓ | | | |
| 3.630 | +/-0.010 | 3.630 | ✓ | | | |
| R0.25 | +/-0.030 | 0.250 | ✓ | | | |
| R0.375 | +/-0.010 | 0.375 | ✓ | | | |
| Ø0.201 | +0.005/-0.001 | 0.200 | ✓ | | | |
| 0.100 | +/-0.010 | 0.102 | ✓ | | | |
| 4.580 | +/-0.010 | 4.580 | ✓ | | | |
| 6.18 | +/-0.030 | 6.180 | ✓ | | | |
| 5.89 | +/-0.030 | 5.8875 | ✓ | | | |
| 0.080 | +/-0.010 | 0.073 | ✓ | | | |
| 0.300 | +/-0.010 | 0.297 | ✓ | | | |
| 30° | +/-0.1° | 30° | ✓ | | | |
| R0.25 | +/-0.030 | 0.250 | ✓ | | | |
| 0.130 | +/-0.010 | 0.1285 | ✓ | | | |
| 0.664 | +/-0.010 | 0.664 | ✓ | | | |
| 0.381 | +/-0.010 | 0.380 | ✓ | | | |
| 0.201 | +/-0.010 | 0.204 | ✓ | | | |
| 0.400 | +/-0.010 | 0.398 | ✓ | | | |
| 0.580 | +/-0.010 | 0.584 | ✓ | | | |
| 100° | +/-0.1° | 100° | ✓ | | | |
| 0.032 | +0.000/-0.010 | 0.027 | ✓ | | | |

| | | | | | |
|---------------------|-------------|--------------------|----------|----------------------------|-----|
| Measured by: | DJP/8.5 | Audited by: | SD | Prototype Approval: | N/A |
| Date: | 08/07/24/25 | Date: | 08/07/25 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | 04.01.12 | New Issue P/O D3121-141 | KJ/RF | |
| B | 04.05.05 | Dimensions changed/re-arranged per Dwg revision | KJ/JLM | |
| C | 06.06.14 | Dwg Rev. updated | KJ/JLM | |
| D | 08.01.16 | Dimensions updated per Dwg Rev. E | KJ/EC/DD | |
| E | 08.05.28 | Tolerance revised for Ø0.201 dimension | KJ/DD | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

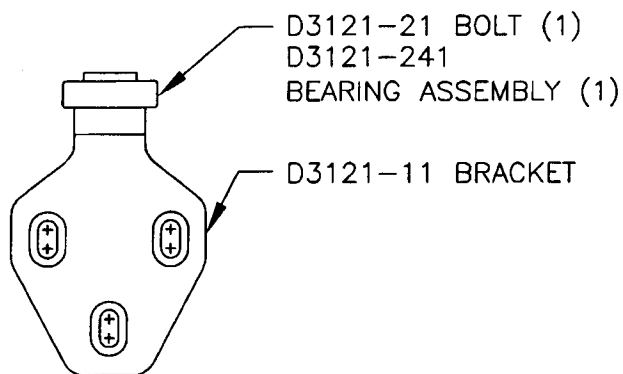
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

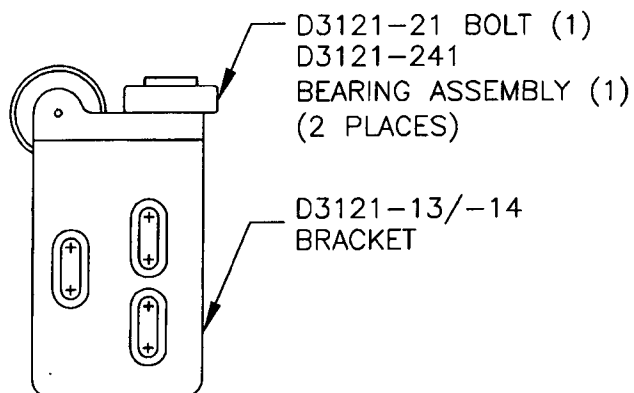


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| DESIGN # | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. E SHEET 1 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |
| A | 02.04.15 | NEW ISSUE | |
| B | 03.01.16 | ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146 | |
| C | 04.02.17 | ADD CLEARANCE; USE -241 BEARING | |
| D | 06.05.17 | D3121-25 CAP WAS 1.024, NOW 1.000 | |
| E | 07.11.07 | ADD TOLERANCE TO 0.032 (DETAIL B) | |

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07.11.07

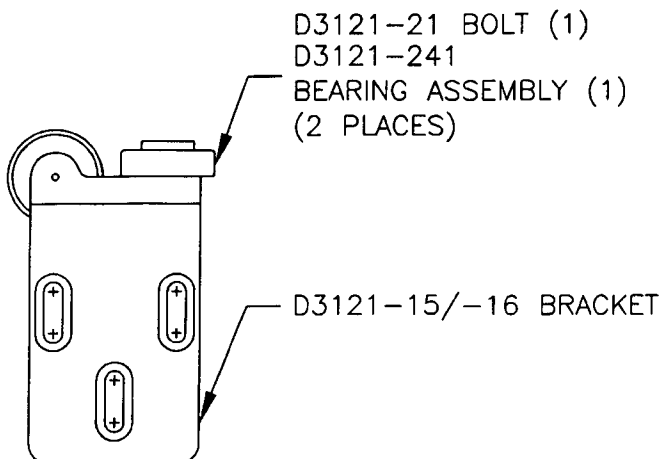


D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)

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**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

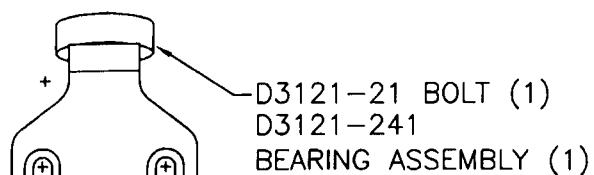
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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| DESIGN # | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. E SHEET 2 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |

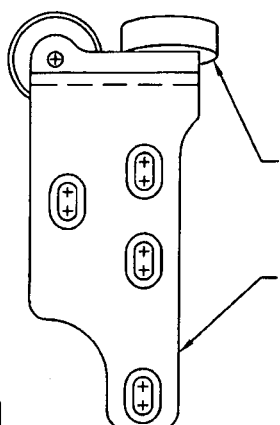


D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

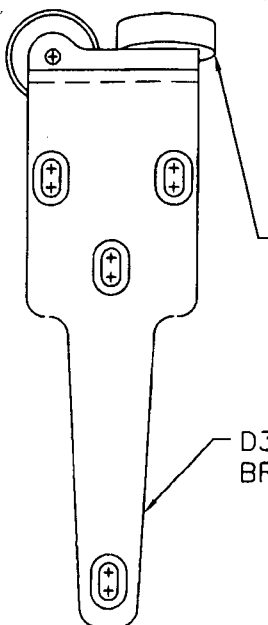
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D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

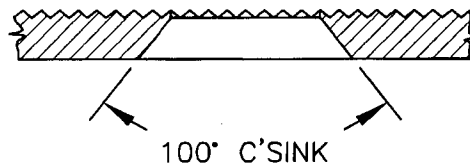
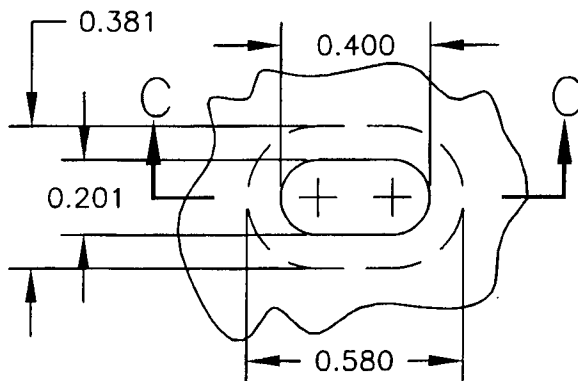
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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| DESIGN # | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. E SHEET 3 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:1 |

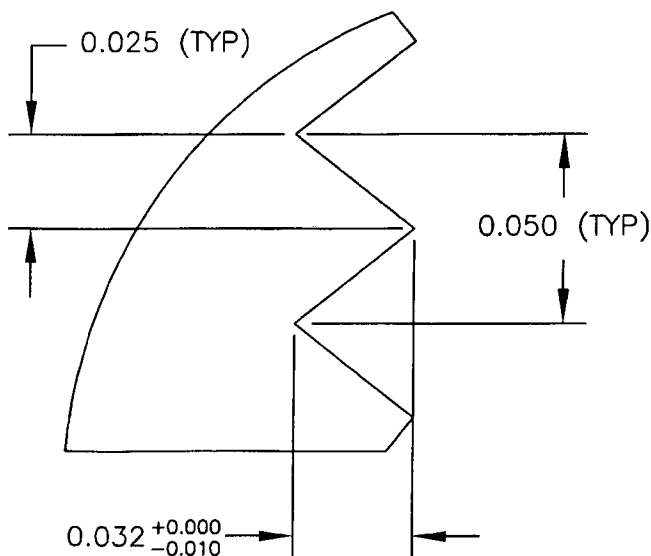
DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

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DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

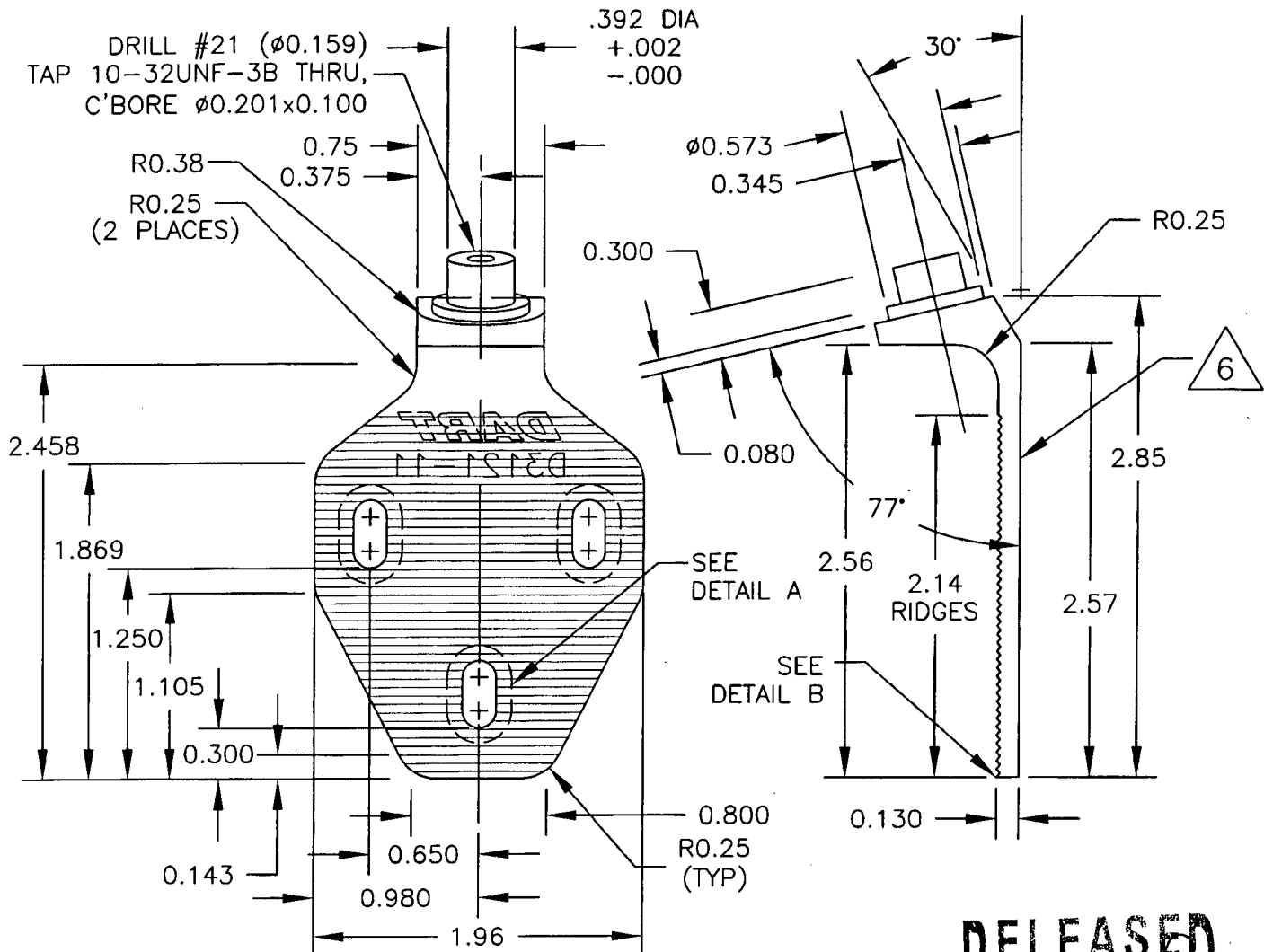
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NOTE: Date & initial all entries

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| DESIGN # | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. E SHEET 4 OF 10 |
| DATE 07.11.07 | TITLE BRACKET ASSEMBLY | | SCALE 1:1 |

**RELEASED**
07.11.07**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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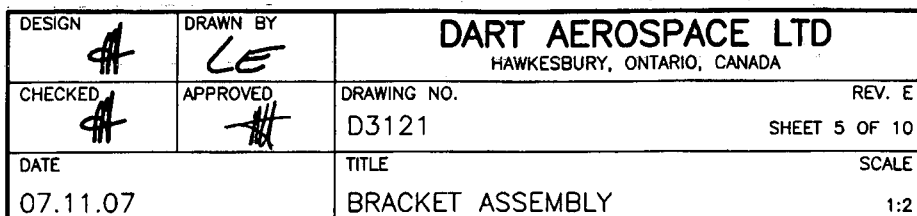
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

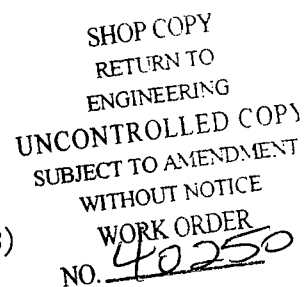
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



RELEASED
07-11-07



- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

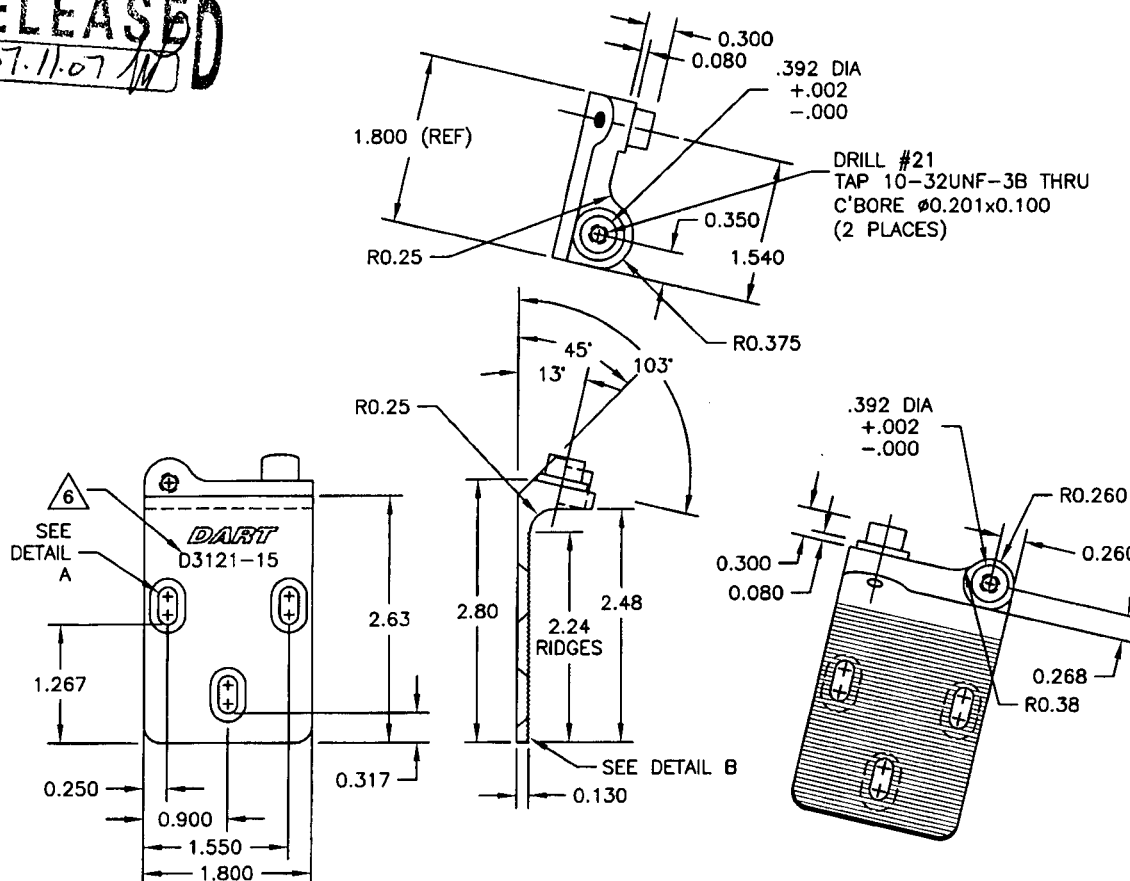
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

DART

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|------------------|----------------|---|-------------------------|
| DESIGN # | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. E SHEET 6 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |

RELEASED
07.11.07

D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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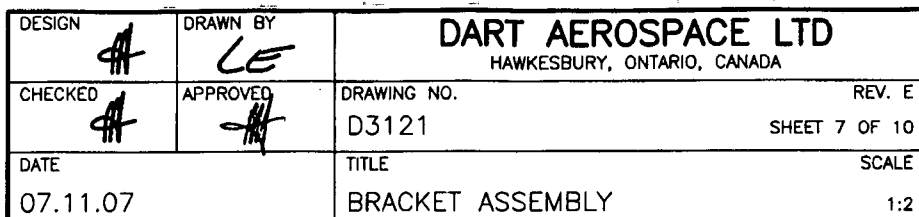
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

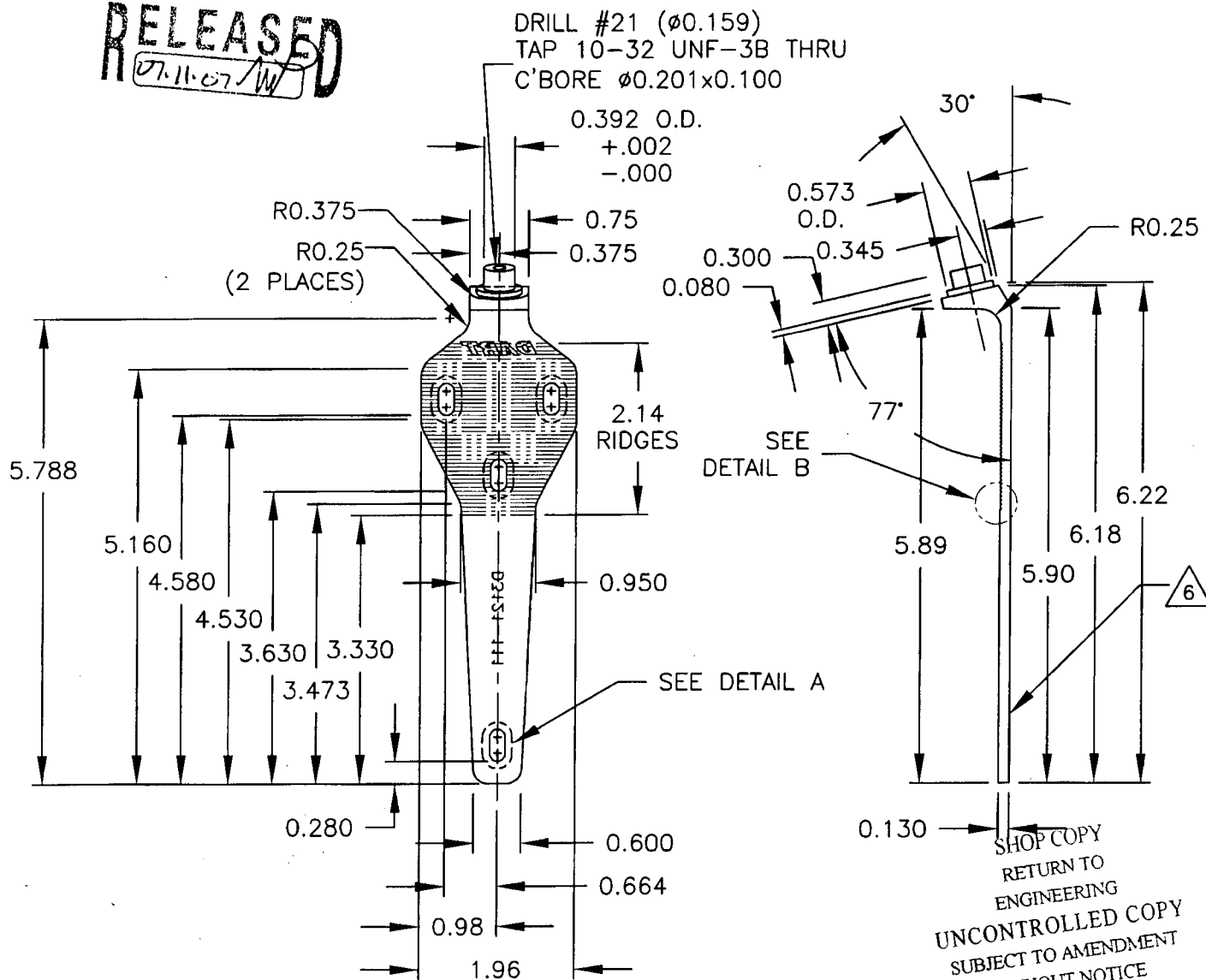
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



RELEASED
07.11.07



- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

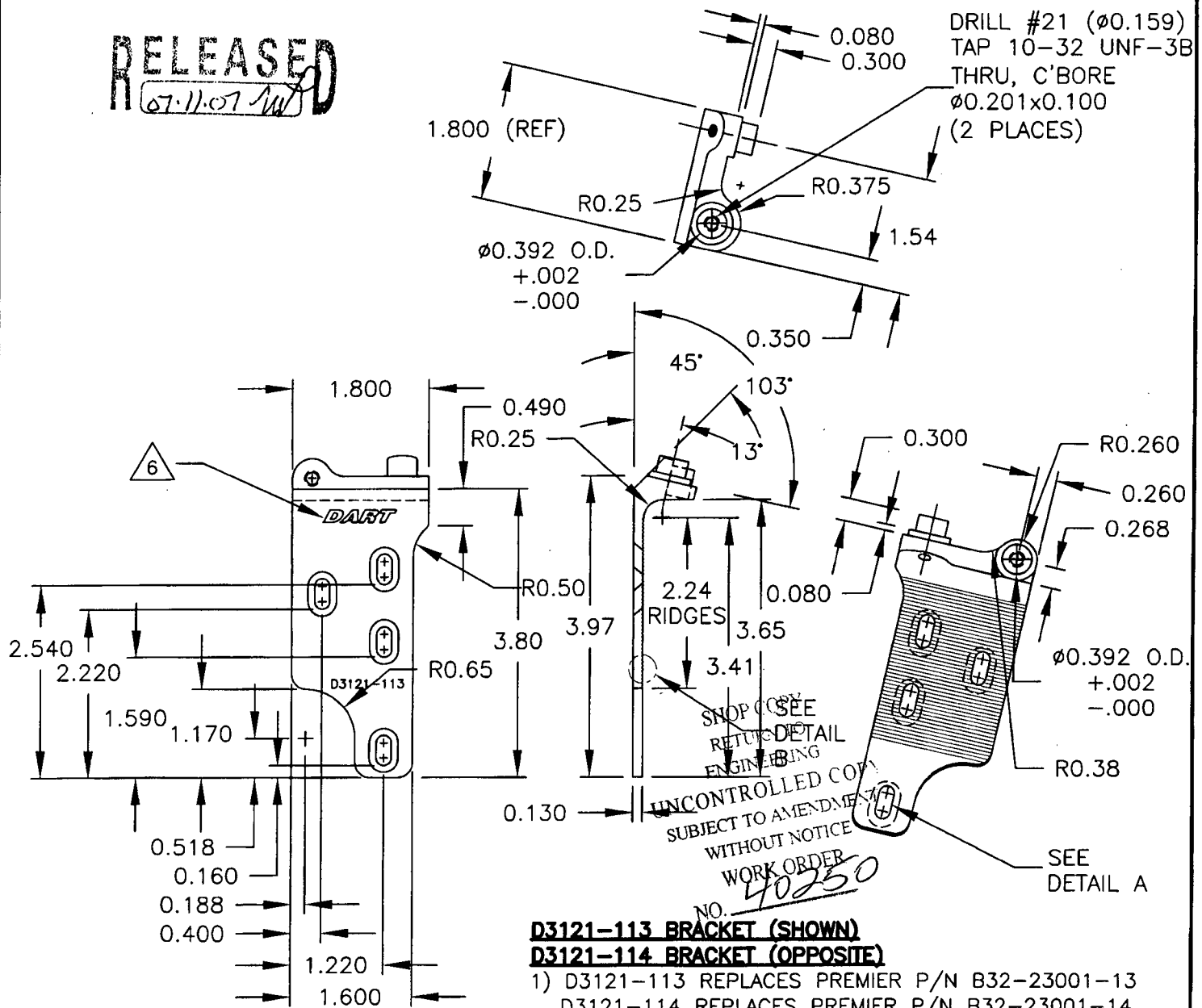
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|------------------|----------------|---|-------------------------|
| DESIGN # | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. E SHEET 8 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |

RELEASED
07.11.07

D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

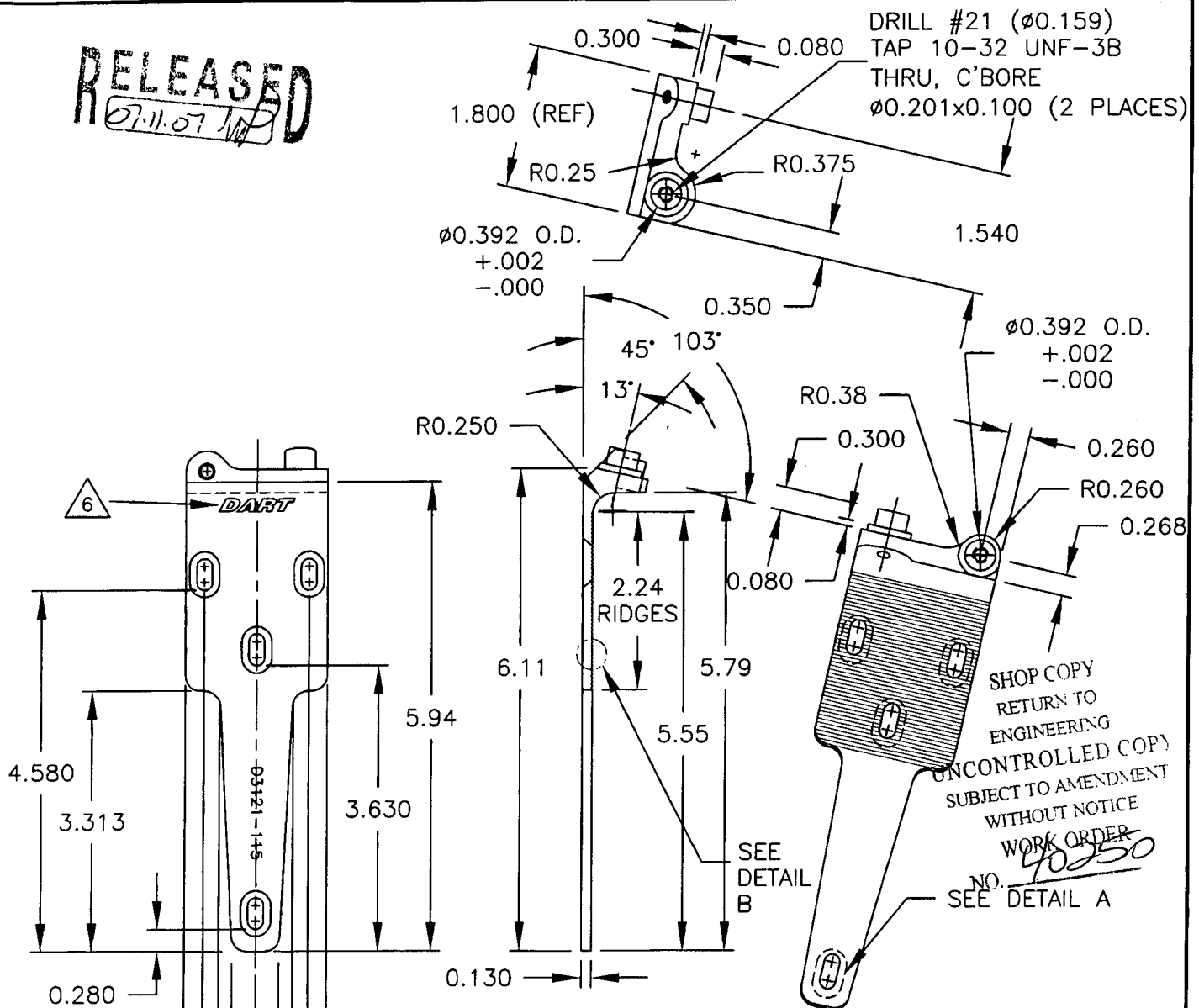
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|------------------|----------------|---|-------------------------|
| DESIGN # | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. E SHEET 9 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |

RELEASED
07.11.07

**D3121-115 BRACKET (SHOWN)****D3121-116 BRACKET (OPPOSITE)**

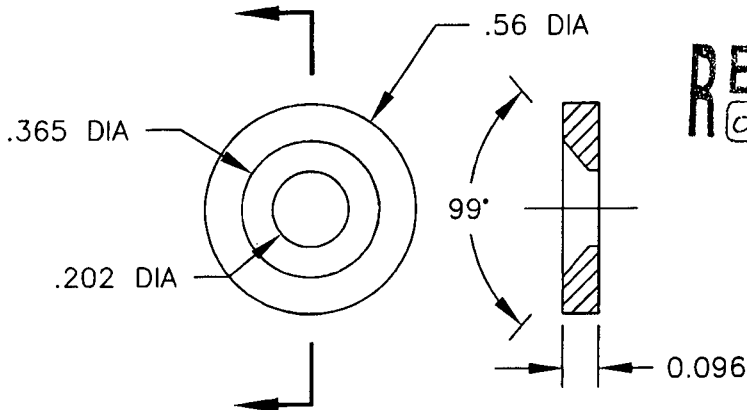
- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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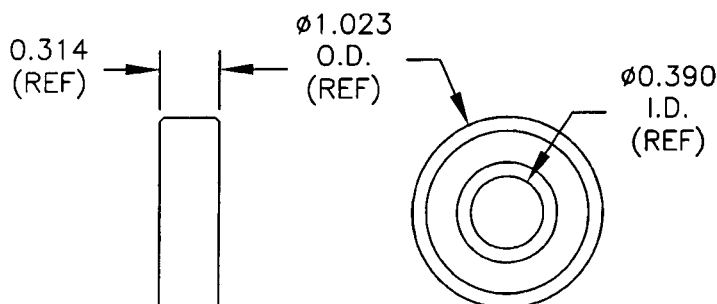
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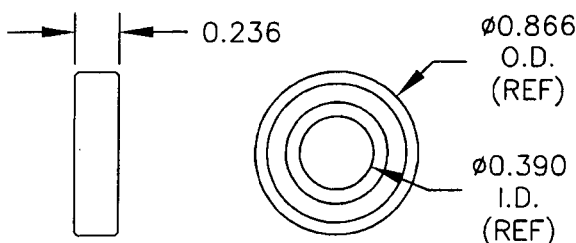
| | | | |
|------------------|----------------|---|--------------------------|
| DESIGN # | DRAWN BY LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. E SHEET 10 OF 10 |
| DATE 07.11.07 | | TITLE BRACKET ASSEMBLY | SCALE 1:1 |

**D3121-17 WASHER (SCALE 2:1)**

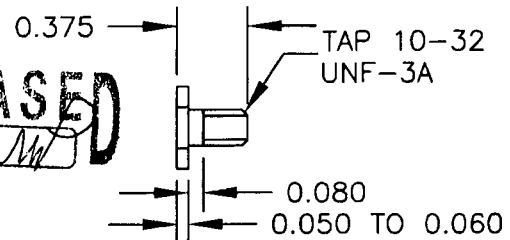
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

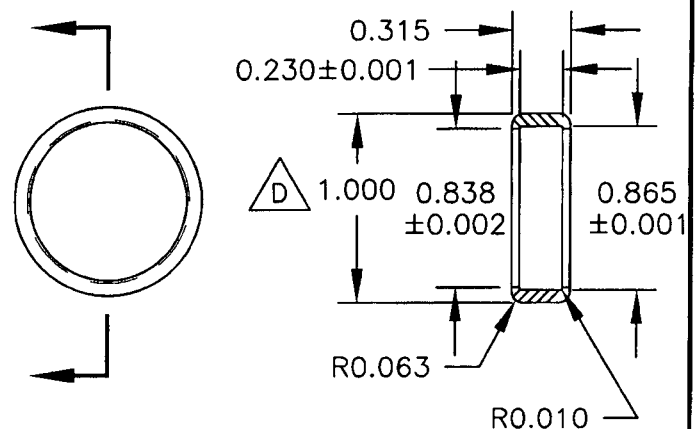
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

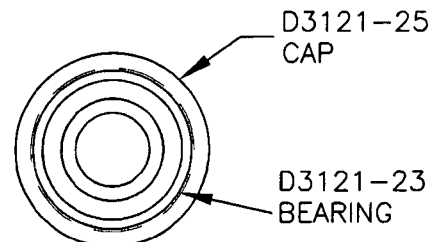
RELEASED
07.11.07**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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